

Work Order ID 76989

76989

Page 1

November-24-11 2:43:24 PM

Item ID: D4072-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Airframe Hinge Backing Plate
 Start Date: 24/11/2011 Start Qty: 10.00 *10* Cust Item ID:
 Required Date: 08/12/2011 Req'd Qty: 10.00 *10* Customer:
 Reference:

Approvals: Process Plan: M.L.J. Date: 11/11/24 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4072	B								
100		0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
6061 .063	Dwg Rev: B								
	Prog Rev: B								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

B12-1-3

22

B12-1-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		5126103		count 22			
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130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00		M/12-01-05		22			
--	---	--------------	--	------------	--	----	--	--	--

140 *140* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo POWDER COAT: 3-30 Start Time: 3200 F Oven Temperature: 4-00 Finish Time:	0.00 0.00							
--	---	--------------	--	--	--	--	--	--	--

m11a480

22x M-12/01/05

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00							
Quality Control									
160	Identify as per dwg & Stock Location: <u>120</u>	0.00							
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

12/1/12 01 09 22
12/1/12 22
12/1/12 MF 12-01-12

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Picklist Print

November-24-11 2:43:28 PM

Page 1

Work Order ID: 76989

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Parent Item: D4072-3

D4072-3

Parent Item Name: Airframe Hinge Backing Plate

Start Date: 24/11/2011

Required Date: 08/12/2011

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A 10.06.08 new issue DD verf:EC
DRAWING REV. CHANGE AS PER ECN 11-598
VERIFIED BY:

IPP REV:B
11-07-05 JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.063

Purchased

No

100

sf

156.5656

0.0087

0.091579

5.

M6061T6S 063

**

1812-1-3

6061-T6 .063 Sheet

Location

Loc Qty

Loc Code

MAT021

156.5655684

116308

18.4555684

117285

88.91

119331

49.2

116308

22

Dart Aerospace Ltd

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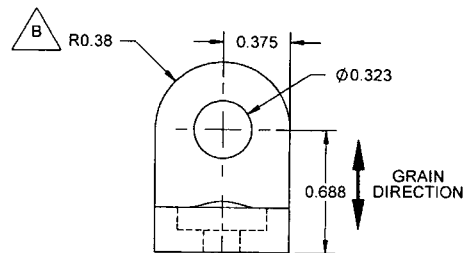
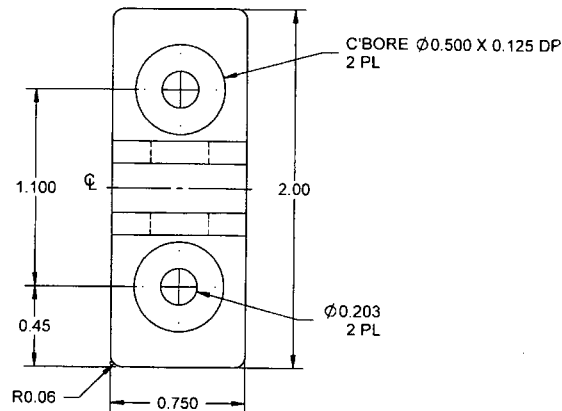
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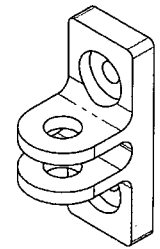
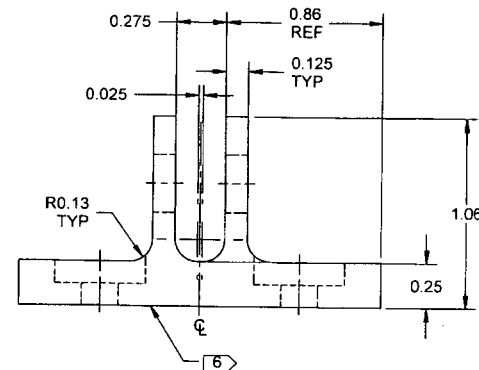
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMEND
WITHOUT NOTICE
WORK ORDER
NO. 76989 M.C.S
11/11/24



D4072-1 AIRFRAME HINGE

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMD 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.04 lbs

RELEASED
2011-06-30
AM

B	CORRECT TYPO (ZN B7-1)	RF	10.11.02
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN	RF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.11.02		
DART AEROSPACE USA, INC. PORT HADLOCK, WA			
DRAWING NO. D4072		REV. B SHEET 1 OF 3	
TITLE AIRFRAME HINGE		SCALE NTS	
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Dart Aerospace Ltd

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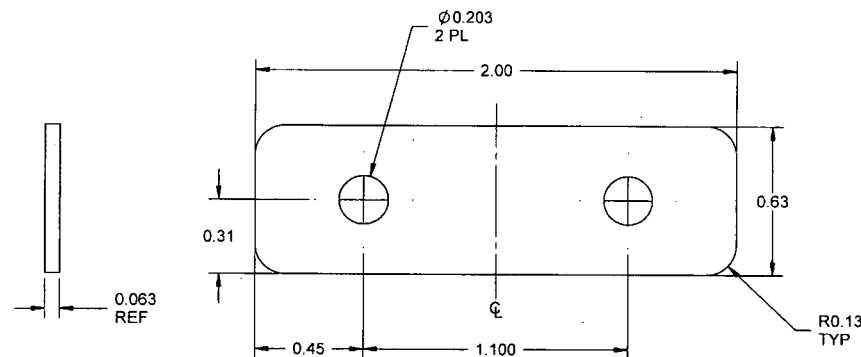
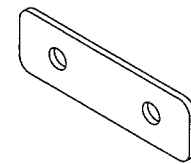
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76989



D4072-3 AIRFRAME HINGE BACKING PLATE

RELEASED
2011-06-30

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC M5061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D4072	SHEET 2 OF 3
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	AIRFRAME HINGE	NTS
DATE	10.11.02	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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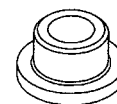
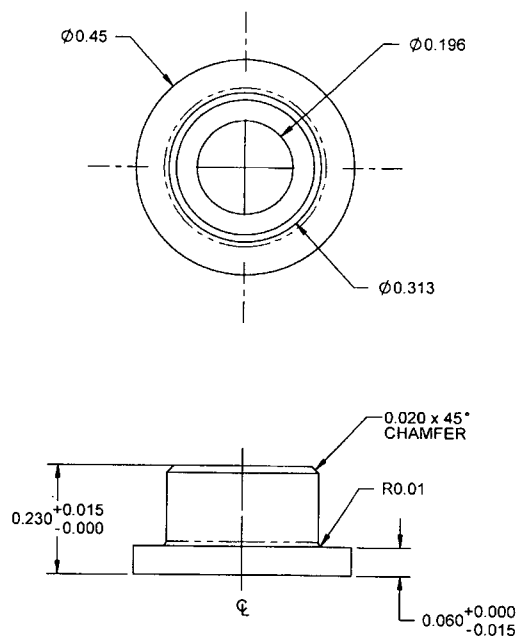
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NOTE: Date & initial all entries

-70989



D4072-5 BUSHING

RELEASED
2011-06-30
JWW

NOTES:

- 1) MATERIAL: AISI 303 STAINLESS STEEL BAR
REF DART SPEC. M303B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.004 lbs

DESIGN	RF	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4072	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	AIRFRAME HINGE	NTS
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